

**Claims:**

1. Apparatus to bend a first and a second cross seal (1, 2) of a bag (3), made of a flexible packaging material, towards the sidewall (5) with:
  - 5 - first means (4) to orient the first cross seal (2) towards the sidewall (5) of the bag,
  - turning means (7) to fix and turn the bag and
  - second means (6) to orient the second cross seal (1) towards the sidewall (5) of the bag.
- 10 2. Apparatus according to claim 1, characterized in that turning means (7) comprises a plane (8) on which the bag is dropped before it is fixed.
3. Apparatus according to claim 1 or 2, characterized in that the turning means  
15 rotate by 180° back and forth.
4. Apparatus according to one of the preceding claims, characterized in that the means (4, 6) are gas ejection means or mechanical means, preferably a plate
- 20 5. Packaging machine (1), especially vertical-type packaging machine, for producing tubular bags (3) from a foil (9) web, characterized in that it comprises an apparatus according to one of the claims 1 – 4.
6. Method to produce a bag (3) made of a flexible packaging material and filled  
25 with a packaging item, characterized in that it is turned while it is produced.
7. Method according to claim 6, characterized in that two cross seals (1, 2) of the bag are oriented towards the sidewall (5) of the bag.
- 30 8. Method according to claim 7, characterized in that the shape of the bag is stabilized by the packaging item.
9. Method according to claim 7 or 8, characterized in that the cross seals (1, 2) are bent towards the sidewall (5) of the bag (3) by the weight of the packaging item.

10. Method to produce a bag (3) made of a flexible packaging material, filled with a packaging item and comprising a sidewall (5), characterized in that the weight of the packaging item is used to support the shaping of at least two sides (10, 11) of the sidewall.

5